

Date: Tuesday, 17/02/2009 10:18:27 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET, GAS SPRING STUD
Job Number : 45814	
Estimate Number : 10183	
P.O. Number :	Part Number : D2154
This Issue : 17/02/2009 S.O. No. :	Drawing Number : D2154 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 44890	Material :
Written By :	Due Date : 20/02/2009 Qty: 30 Um: Each
Checked & Approved By : <u>JLD 09.02.17</u>	
Comment : Est: C 03.08.08 Reformat; Remove Tumble KJ/RF Est Rev:D NowOn Waterjet 07-04-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.0350 sf(s)/Unit Total : 1.0490 sf(s)
 304/316 .063 Sheet
 Batch: 110551

M 09 02 20 (30)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2154
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

M 09/02/23 (30x)

M 09 02 20 (30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 09 02 20

(30)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J 09/02/23 (30x) count

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

M 09 02 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:27 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154 Rev: C

SB 09/03/06 (30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
S 02/02/06 (x30)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

8:15

OVEN TEMPERATURE:

400°

FINISH TIME:

8:45

uno/ff

09/03/11

(X30)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-11

(X30)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 17

9/3/11

SD

(304)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12

Job Completion



mf
09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

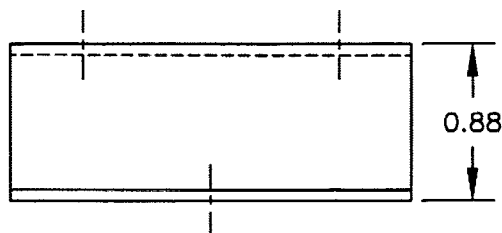
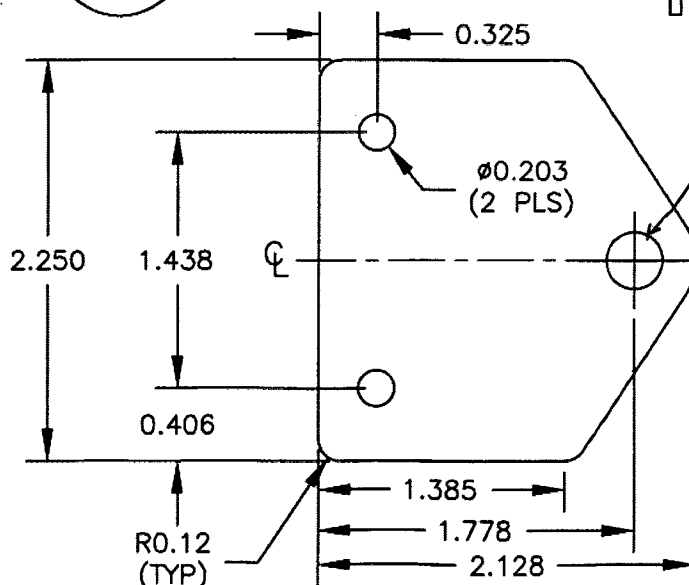
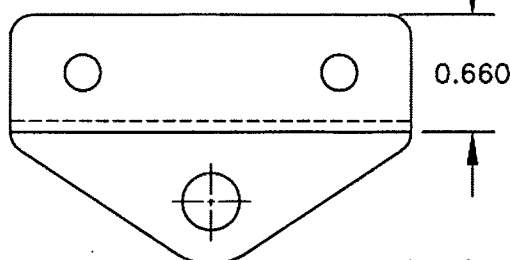
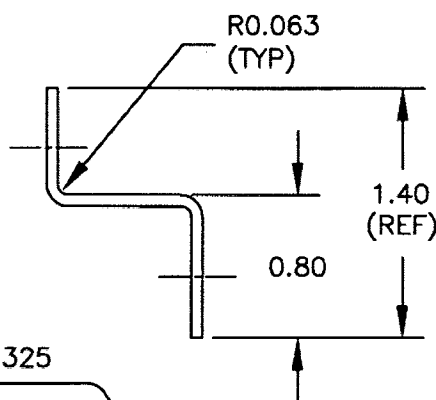
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45814

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